



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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C3-C-1

Job Sheet 200760



Part No: C3-C-1

Job Qty: 1 pcs

Part Name: Weldment C3 Cage



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/17/19

Job Tracking No:

Due Date: 10/31/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 19302

Note: DWG C3-C Rev J IPP Rev A 18.03.28 New issue DP Verify DD/IPP Rev. B 19.04.25 drawing revision DP Verify DD/IPP Rev. C 19.05.03 drawing revision DP Verify DD/IPP Rev. D 19.07.23 drawing update DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off	
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time		
100	Large Fab - Welded Assy-1	1 pcs	10/31/19		0.00	10.00	Large Fab - 1		MW	
							Large Fab - 10			
							Large Fab - 2			
							Large Fab - 3			
							Large Fab - 4			
							Large Fab - 5			
							Large Fab - 6			
							Large Fab - 7			
							Large Fab - 8			
							Large Fab - 9			
							Large Fab - 11 (Various)			
110	QC 9	1 pcs	10/31/19		0.00	0.00	QC 9 - 10		a	
							QC 9 - 18			
							QC 9 - 24			
							QC 9 - 43			
							QC 9 - 50			
							QC 9 - 9			
			10/31/19		0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			



DART
AEROSPACE

Container No: S227277



Material No: 200760
Material No/Batch: S227277

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A
CANADA
TEL.: 1 813 632-52
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Plex 9/17/19 1:29 PM Dart.Renwick.Jennifer



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Hawkesbury, ON K6A
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Container No: S227277



rC3-C-1

b No: 200760

rial No/Batch: S227277

ision: J

nator:

						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	2
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
130 Powdercoat - 6 Fire Red - B4B	1 pcs	10/31/19	0.00	0.50		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BF 19-10-20
						Powdercoat - 4 - B4B	
140 QC 3	1 pcs	10/31/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	DAS 30 OCT 30 2019
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
150 Packaging 3-1 - Stock - B4B	1 pcs	10/31/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	DAS 30 OCT 30 2019
						Packaging 3 - 8 - B4B	9-82
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	

160	QC 21 - SA	1	10/31/19	0.00	0.00	QC 21 - SA - 21	OCT 30 2019
		pcs				QC 21 - SA - 70	
						QC 21 - SA - 53	

Part Op 100 - 1-Fabricate C3-C-3, C3-C-4 and C3-C-5. 2-TACK WELD FOR INSPECTION BY: USE WELDING JIG
criptions: C3-19C. 2-Weld as per DWG. ***See notes 8,9,10 and 11***
110 - QC9- Inspect visual per QSI004- Fusion Welds
120 - QC5- Inspect part completeness to step on W/O
130 - Fire Red(Ref:4.3.5.10) per QSI005 4.3 START TIME: 11:00 OVEN TEMPERATURE: 300° FINISH
TIME: 11:30 M 225472
140 - QC3- Inspect Part Finish Ink stamp will be done on top level assembly.
150 - 1-Identify as per dwg & Stock Location SA160 2-Ink stamp will be done on top level assembly, identify with green
tag.
160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
C3-C-2	Lifting Plate	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5 217 546
C3-C-6	Bumper Bracket	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5 219 520
C3-C-7	Boss	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5 181 047
MT-A513-T-1.000W0.120	A513 Seamless Alloy Steel Round Tubing 1"dia. x 0.120" Wall	8.7000 ft (8.7 ea)	100-Large Fab - Welded Assy-1	5 200 823

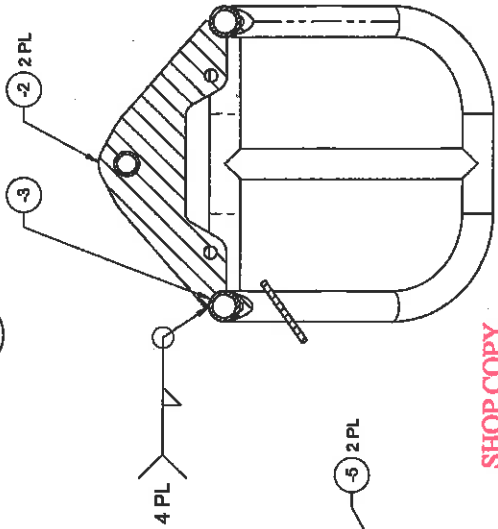
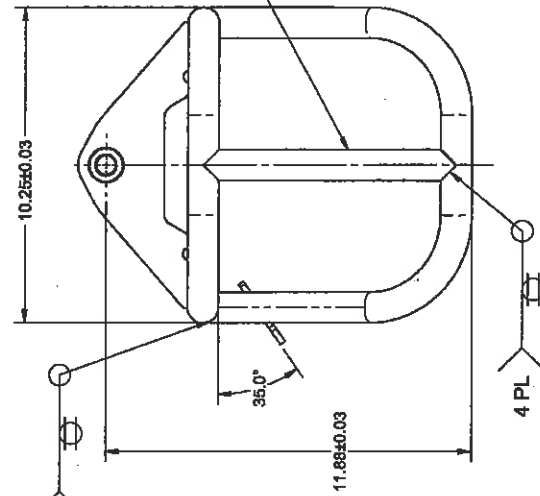
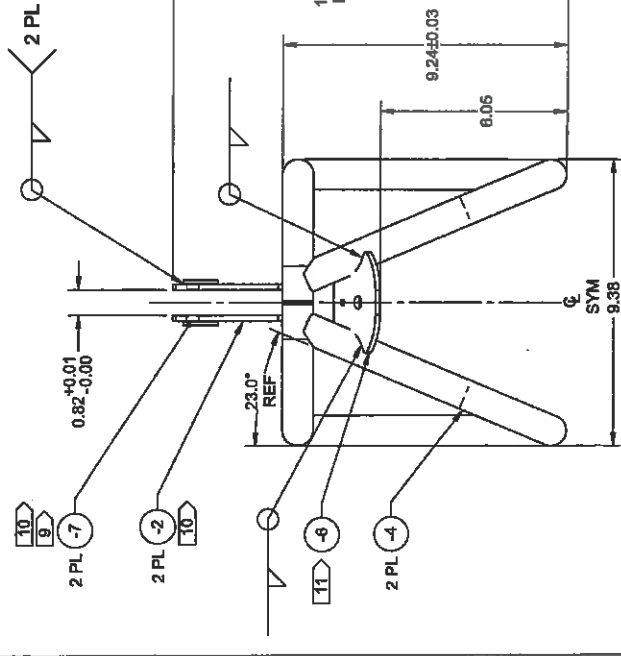
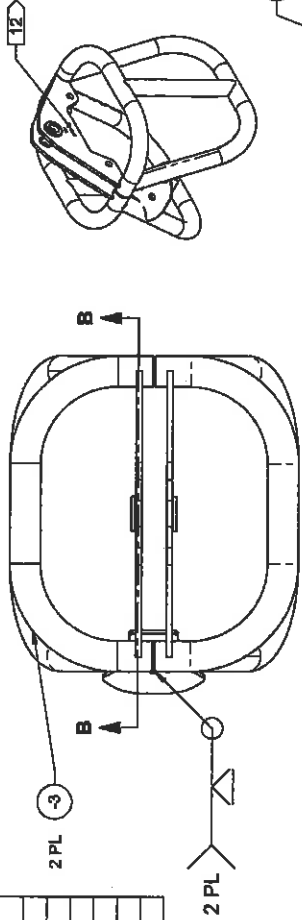
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	C3-C-2	2	0	0
	C3-C-6	1	4	0
	C3-C-7	2	0	0
	MT-A513-T-1.000W0.120	9	163	0

Part Specifications

Specifications could not be found.

ITEM #	QTY	PART #	PART TITLE
-2	2	C3-C-2	LIFTING PLATE
-3	2	C3-C-3	TOP SEMI-RING
-4	2	C3-C-4	SIDE LOOP C3 CAGE
-6	2	C3-C-5	STIFFENER BAR
-8	1	C3-C-6	BUMPER BRACKET
-7	2	C3-C-7	BOSS



SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 200760

C3-C-1 WELDMENT C3 CAGE

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: POWDER COAT RED QSI 005 OR MIL-PRF-24712
 - 4) TOLERANCES: XX = $\pm 0.1"$ / $\pm 0.5"$
XXX = $\pm 0.005"$ / $\pm 0.1"$
XXXX = $\pm 0.0005"$ / $\pm 0.05"$
XXXXX = $\pm 0.0001"$ / $\pm 0.01"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLY: N/A
 - 8) USE WELD FILLER C3-C-1, 100% TIG, AND WELD SPATTERS
 - 9) USE WELD FILLER C3-C-1, 100% TIG, AND WELD SPATTERS
 - 10) HOLES OF BOTH SETS OF -2 AND -7 MUST ALIGN.
 - 11) TRIM ITEM#6 BUMPER BRACKET AS REQUIRED TO MATCH TUBES PROFILE FOR WELDING.
 - 12) INK STAMP TIN AND SIN PER QSI 044 AFTER POWDER COAT

DESIGN DRAWN
CHECKED
MFG. APPR.
APPROVED
DATE 2019-07-10

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
REV. J
SHEET 2 OF 11
SCALE
NTS
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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: _____